



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

**D2885****Job Sheet 183864****Part No:** D2885**Job Qty:** 10 ea**Part Name:** Saddle Spacer**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 9/27/18**Job Tracking No:****Due Date:** 10/5/18**Created By:** Michelle Gagnon-Donovan**Type:** Stock**Description:**

**Note:** DWG REV B IPP A 99.10.12 New Issue EC IPP Rev:B Now 6060-T6 06-06-23 JLM IPP Rev:C waterjet 06-07-23 ec

**Ship Via:****Bill of Materials****Job Routing**

| Op No | Operation  | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off         |
|-------|------------|--------|------------|----------|-----------|---------|-----------------------|-----------|------------------|
|       |            |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                  |
| 100   | Waterjet   | 10 pcs |            | 10/5/18  | 0.00      | 0.15    | Waterjet 1            |           | SC 18/10/01      |
| 110   | QC         | 10 pcs |            | 10/5/18  | 0.00      | 0.00    | QC2 Waterjet-1        |           | SC 18/10/01      |
| 120   | QC         | 10 pcs |            | 10/5/18  | 0.00      | 0.00    | QC8-1                 |           | 38               |
| 130   | HandFinish | 10 pcs |            | 10/5/18  | 0.00      | 0.06    | HandFinish1           |           | D.R. 18/10/15    |
| 140   | QC         | 10 pcs |            | 10/5/18  | 0.00      | 0.00    | QC7-1                 |           | 38               |
| 150   | Packaging  | 10 pcs |            | 10/5/18  | 0.00      | 0.00    | Packaging3            | 57013     | OCT 15 2018 8-00 |
| 160   | QC21-SA    | 10 Ea  |            | 10/5/18  | 0.00      | 0.00    | QC21                  |           | 9-00             |

Part Op 100 - 1-Cut as per Dwg D2885 Dwg Rev: B Prog Rev: B 2-Deburr if necessary  
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB  
 120 - QC8- Inspect parts - second check  
 130 - Chemical Conversion Coat per QSI005 4.1  
 140 - QC7-Inspect Chemical Conversion Coat  
 150 - Identify as per dwg & Stock Location: \_\_\_\_\_  
 160 - QC21- Final Inspection - Work Order Release

DAG  
21  
9-00

OCT 15 2018

**Job BOM**

| Part / Item  | Component Name     | Quantity            | Operation    | Container |
|--------------|--------------------|---------------------|--------------|-----------|
| M6061T6S.080 | 6061-T6 .080 Sheet | .2570 sf (.0257 ea) | 100-Waterjet | 5099480   |

**Job Allocations**

| Operation    | Component Part | Required | Inventory | Allocated |
|--------------|----------------|----------|-----------|-----------|
| 100-Waterjet | M6061T6S.080   | 0        | 13        | 0         |

1250 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: [sales@dartaero.com](mailto:sales@dartaero.com)  
[www.dartaerospace.com](http://www.dartaerospace.com)



**Instructions: Various STC's**

Date: 10/04/18

| Part Specifications |               |                                |                  |       |                  |
|---------------------|---------------|--------------------------------|------------------|-------|------------------|
| Spec No             | Description   | Target/Tolerance               | Limits           | Type  | Special Comments |
| 1                   | Saddle Spacer | 0.430Inches $\pm$ 0.030        | 0.460<br>0.400   | 0,429 |                  |
| 2                   | Saddle Spacer | 0.443Inches $\pm$ 0.010        | 0.453<br>0.433   | 0,440 |                  |
| 3                   | Saddle Spacer | 0.257Inches + 0.006<br>- 0.001 | 0.263<br>0.256   | 0,257 | Diameter         |
| 4                   | Saddle Spacer | 0.300Inches $\pm$ 0.030        | 0.330<br>0.270   | 0,300 | Radius           |
| 5                   | Saddle Spacer | 0.679Inches $\pm$ 0.010        | 0.689<br>0.669   | 0,680 |                  |
| 6                   | Saddle Spacer | 0.400Inches $\pm$ 0.030        | 0.430<br>0.370   | 0,400 | Radius           |
| 7                   | Saddle Spacer | 0.250Inches + 0.030<br>- 0.000 | 0.280<br>0.250   | 0,254 |                  |
| 8                   | Saddle Spacer | 0.672Inches $\pm$ 0.010        | 0.682<br>0.662   | 0,670 |                  |
| 9                   | Saddle Spacer | 0.521Inches $\pm$ 0.010        | 0.531<br>0.511   | 0,520 |                  |
| 10                  | Saddle Spacer | 1.340Inches $\pm$ 0.010        | 1.350<br>1.330   | 1,344 |                  |
| 11                  | Saddle Spacer | 2.681Inches $\pm$ 0.010        | 2.691<br>2.671   | 2,680 |                  |
| 12                  | Saddle Spacer | 3.710Inches $\pm$ 0.030        | 3.740<br>3.680   | 3,712 |                  |
| 13                  | Saddle Spacer | 0.380Inches $\pm$ 0.030        | 0.410<br>0.350   | 0,380 | Radius           |
| 14                  | Saddle Spacer | 0.528Inches $\pm$ 0.010        | 0.538<br>0.518   | 0,530 |                  |
| 15                  | Saddle Spacer | 0.080Degrees $\pm$ 0.500       | 0.580<br>(0.420) | 0,080 | Angle            |

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